

Work Order ID 87049

87049

Page 1

July-10-12 2:59:51 PM

Item ID: D2654-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web

Start Date: 10/07/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 24/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/07/10

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2654

F

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-7 to length as per Dwg D2654
2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654
3-Using the uni-bit, open holes to finish size as per Dwg D2654
4-Deburr holes and ends

4 SAD ~~12-07-11~~
12-07-11

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

4 0 BE 12-07-11

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

4 MB 12-7-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/7/13	100	Qty (3) of the beams have the fwd-most and aft-most hole off by $\approx 1/8"$ RC sig was starting to wear out	CP 12/7/13	Acceptable to open holes up to $\phi 0.650$ to allow xxx x-bolt spacers to install. Replace Jcy. DT 8018-5	OC 12/7/13	CF 12-7-16	CP 12/7/13	DAS 16 17/01/16

NOTE: Date & initial all entries

Work Order ID 87049

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Page 2

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Item ID: D2654-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Web

Stop

NS2

Start Date: 10/07/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 24/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

4 SAD B-0712

4 CF 12-1-12

MLJ 12/07/16

MLJ 12/07/12

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 87049

87049

Parent Item: D2654-5

D2654-5

Parent Item Name: Wcb

Start Date: 10/07/2012

Required Date: 24/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-7-140

Manufactured No

100

Each

128.0000

1

4

D2600-7-140

EXT. "I BEAM" THICK

**

SAD 12-07-11

Location

Loc Qty

Loc Code

LG

128

41591

3

72279

125

4

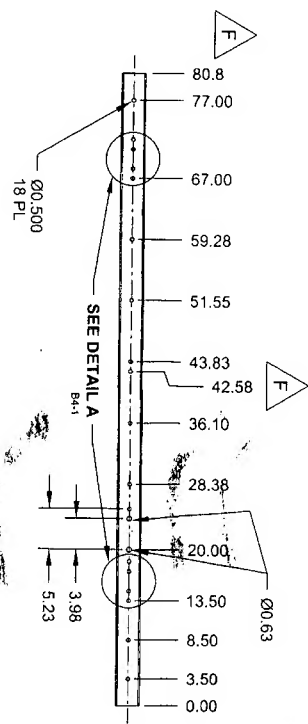
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2654-3 WEB

REV	DESCRIPTION	CP
B5-2	NEW ISSUE	CP 97.03.25
B3-2	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP 97.05.26
D3-2	CHANGED HOLE PATTERN	CP 97.10.29
C3-1	GIW HOLE CHANGED TO 90.63	CP 98.01.15
C3-1	CHANGE LENGTHS, REFORMAT	CP 94.05.26
F	ADDED ADDITIONAL HOLES E-N -54.7, 80.8 WAS 80.5, INCORPORATED DEO D2864-E-2	SC 11.03.05

DESIGN	CP	DESCRIPTION	BY	DATE
DRAWING	SC	DART AEROSPACE USA, INC		
CHECKED	<i>CP</i>	PORT HADLOCK, WA		
MFG. APPR.	<i>CP</i>	DRAWING NO.	REV. F	
APPROVED	<i>CP</i>	D2654	SHEET 1 OF 2	
DE APPR.	<i>CP</i>	SCALE	NTS	
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC ALL RIGHTS RESERVED. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.		

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2011-09-12
JW

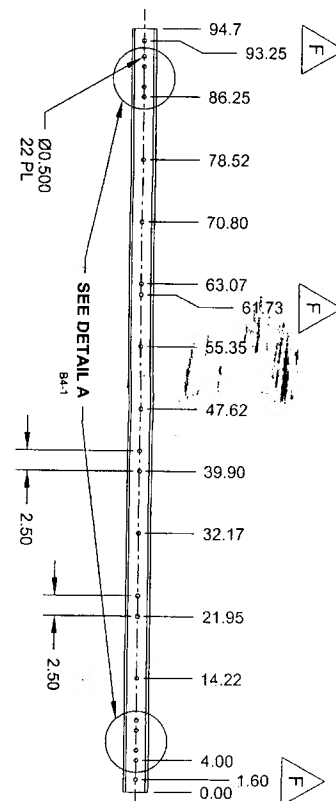
Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

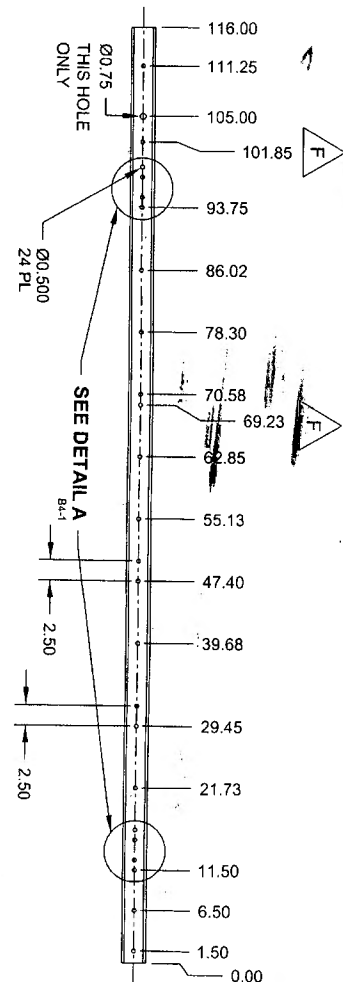
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NOTE: Date & initial all entries



D2654-5 WEB

27049



D2654-7 WEB

DESIGN	CP	DART AEROSPACE USA, INC
DRAWN	SC	PORT HADLOCK, WA
CHECKED	Q	DRAWING NO.
MFG. APPR.	Q	D2654
APPROVED	Q	TITLE
DE APPR.	Q	WEB
DATE	11.05.05	SCALE
		NTS

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R 2011-09-12

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